

# Work Order ID 103264

Thursday, June 20, 2013 11:31:08 AM

**\*103264\***

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*RUSTI*

Item ID: D3705-1

Accept

**\*N9000040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: MAIN PANEL

Stop **\*NS2\***

Start Date: 6/20/2013 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 6/24/2013 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *13-6-20*

Tooling:

Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3705

E

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3705

Dwg Rev: *E*

Prog Rev: *E*

\*\*\*grain direction\*\*\*

2- Deburr if necessary

*7 0 13.06.20*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

*7 0 13.06.20*

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Item ID: D3705-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: MAIN PANEL  
 Start Date: 6/20/2013 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 6/24/2013 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							DAS 09 9-83
Quality Control									
130	Small Fab	0.00							
<b>*130*</b>									
Small Fab	Memo	0.00							
Small Fab	1-COUNTER SINK AS PER DWG 2- BEND AS PER DWG D3705								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

① 13-06-24

7

*[Handwritten signature]*  
13/06/25

*[Handwritten signature]*  
13 6 25

7

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 6/20/2013      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 6/24/2013      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

## Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

150

Identify as per dwg & Stock Location: W/A as

0.00

**\*150\***

## Packaging

## Memo

0.00

## Packaging

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

13/6/27

11 (B-062)

# Picklist Print

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Work Order ID: 103264

Parent Item: D3705-1

Parent Item Name: MAIN PANEL

Start Date: 6/20/2013

Required Date: 6/24/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-01-30 new issue EC verified by:DD  
 IPP Rev:B 09-01-09 rev.C as per dwg DD verified by:EC  
 IPP Rev:C as per dwg RevD DD 10.04.27 verified by:EC IPP REV:D 13.01.15 AS PER DWG  
 REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080		Purchased	No			100	sf	287.8100	2.16	9.0947368			
6061-T6 .080 Sheet													

Location

Loc Qty

Loc Code

MAT

0.2

124572

0.2

MAT021

287.61

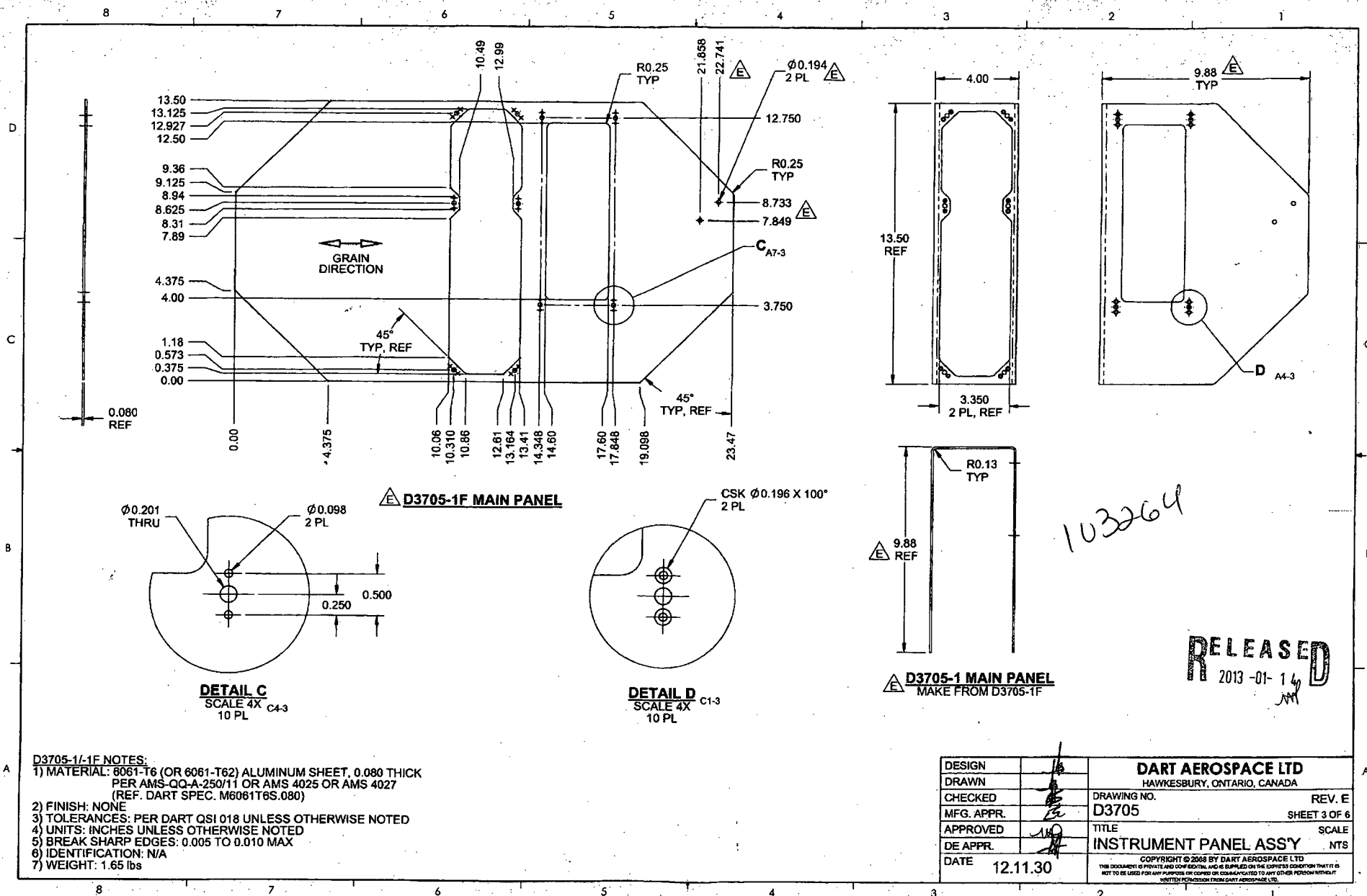
m125812

287.61

125812

159.97

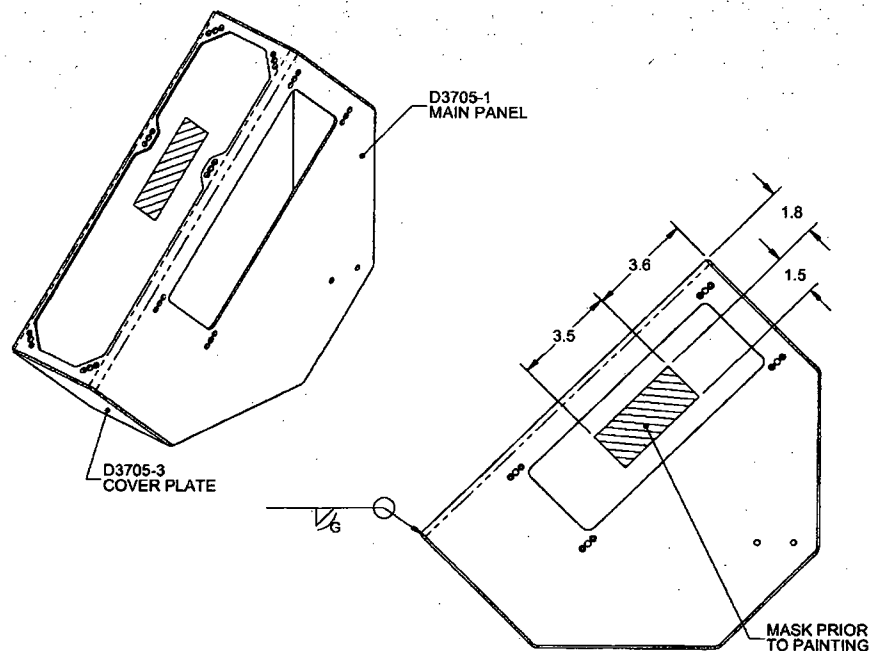
13.06.20



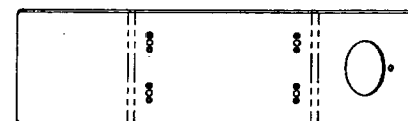
# D3705-1F NOTES:

- 1) MATERIAL: 8061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.65 lbs

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE



103264



**D3705-043 INSTRUMENT PANEL WELDMENT**

**D3705-043 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.20 lbs
- 8) WELDING: PER DART QSI 004

**RELEASED**  
2013-01-14

DESIGN	1/6	<b>DART AEROSPACE LTD</b>	
DRAWN	1/6	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1/6	DRAWING NO.	REV. E
MFG. APPR.	1/6	D3705	SHEET 2 OF 6
APPROVED	1/6	TITLE	SCALE
DE APPR.	1/6	INSTRUMENT PANEL ASSY	NTS
DATE	12.11.30	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 103264
<b>Description:</b> Main Panel		<b>Part Number:</b> D3705-1
<b>Inspection Dwg:</b> D3705	<b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.102	-		✓	JKM-01
Ø0.201	+0.005/-0.001	0.206	-		✓	JKM-01
4.375	+/-0.010	4.375	-		✓	JKM-01
9.31	+/-0.030	9.315	-			
9.560	+/-0.010	9.563	-			
12.414	+/-0.010	12.414	-			
12.66	+/-0.030	12.66	-			
13.598	+/-0.010	13.598	-			
13.85	+/-0.030	13.85	-			
16.85	+/-0.010	16.85	-			
17.098	+/-0.010	17.098	-			
17.598	+/-0.010	17.598	-			
21.97	+/-0.030	21.97	-			
0.375	+/-0.010	0.378	-			
0.573	+/-0.010	0.570	-			
4.00	+/-0.030	4.008	-			
4.375	+/-0.010	4.377	-			
8.31	+/-0.030	8.31	-			
8.625	+/-0.010	8.625	-			
8.94	+/-0.030	8.952	-			
9.125	+/-0.010	9.125	-			
12.50	+/-0.030	12.50	-			
12.927	+/-0.010	12.927	-			

<b>Measured by:</b> A. Jm	<b>Audited by:</b> DAS 09	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 13-06-11	<b>Date:</b> 13-06-11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.15	New Issue	KJ	